Work Order ID 99638

99638

April-11-13 2:28:43 PM

Item ID: D3457-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Washer **Stop** *NS2*

Start Date: 5/24/13 **Start Qty:** 24.00 *24*

Required Date: 5/24/13 **Req'd Qty:** 24.00 *24*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** [signature] **Date:** 13-04-16 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3457	Rev A								
100	DOOSAN LATHE	0.00				24	Ø		
100									
Doosan	**Memo**	0.00							
Doosan Lathe	Turn as per Folio FA589 Rev: N/A & Dwg D3457 Rev: A				13-4-23	SA			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110					13-4-23	SA	24	Ø	
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120					FK 13/04/23		23	Ø	
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

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April-11-13 2:28:43 PM

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Required Date: 5/24/13 **Req'd Qty:** 24.00 *24* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location ST 04/7	0.00							
130						23X			SP 13-4-24
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140							13/4/25		
QC	**Memo**	0.00							
Quality Control									

AB 04-25

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

April-11-13 2:28:43 PM

Work Order ID: 99638

Parent Item: D3457-1

Parent Item Name: Washer

Start Date: 5/24/13 **Required Date:** 5/24/13

Start Qty: 24.00 **Required Qty:** 24.00

Comments: IPP A05.10.03New issueKJ/JLM
IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000 Delrin Round Bar 1"		Purchased	No			100	f	48.0000	**0.0208**	**0.5254728**			

Location	Loc Qty	Loc Code
MAT018	48	
125251	48	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Water Jet ☐
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Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
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DART AEROSPACE LTD	Work Order:	99638
Description: Washer	Part Number:	D3457-1
Inspection Dwg: D3457 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.575	+/-0.010	R 1.575	✓		R.G.	
0.030 x 0.030	+/-0.010	.030 x .030	✓		S/-4	U/L
0.530	+/-0.010	.525	✓			
0.063	+/-0.010	.064	✓			
0.169	+/-0.010	.167	✓			
Ø0.655	+/-0.010	Ø .654	✓			
Ø1.000	+/-0.010	Ø 1.003	✓			

Measured by:		Audited by:	F.K.	Prototype Approval:	N/A
Date:	13-4-23	Date:	13/04/23	Date:	N/A

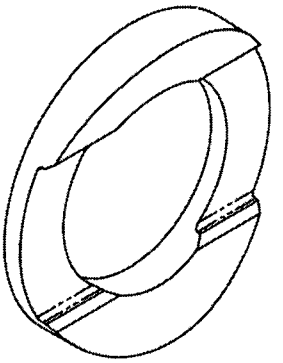
Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/EC	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3457	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.06		WASHER	2:1

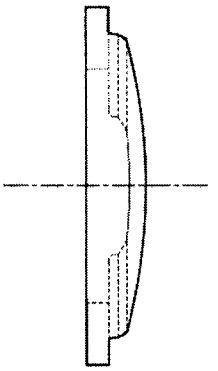
A	05.09.06	NEW ISSUE

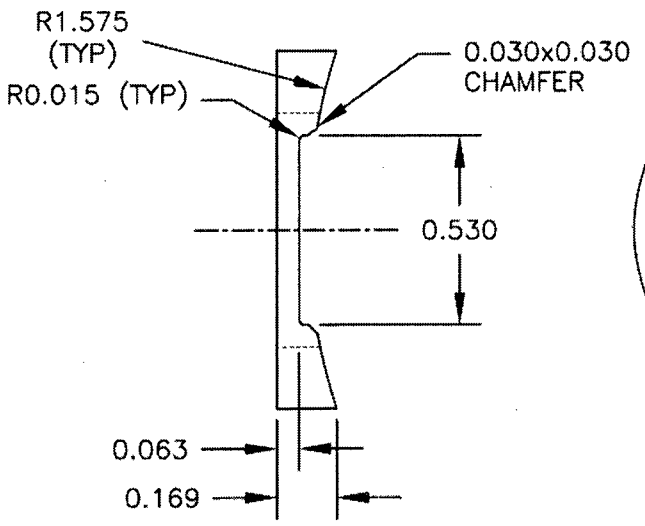
RELEASED
05.09.06

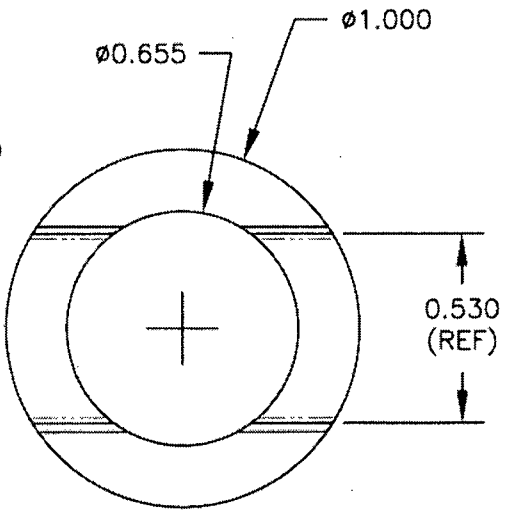
99438
Rl 13-04-14



ISOMETRIC DETAIL







D3457-1 WASHER

1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
2) FINISH: NONE
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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